

Work Order ID 59873

Tuesday, June 15, 2010 1:06:12 PM



Page 1

Item ID: D2585

Accept



Setup Start



Revision ID:

Item Name: Mounting Channel

Stop



Start Date: 6/15/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-6-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2585	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2585

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

304 . 080

AB 10-6-22



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

AB 10-6-22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/06/23

counter
(+26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59873

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Page 2

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Start Date: 6/15/2010 Start Qty: 20.00

Required Date: 6/21/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

=> m-h 10/06/23

(26x)

140



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D2585

0.00

0.00

SB 10/06/28

(26)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/06/28

cont
(26)

W/O:		WORK ORDER CHANGES					
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Work Order ID 59873

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Item ID: D2585

Accept



Setup Start



Revision ID:

Item Name: Mounting Channel

Stop



Start Date: 6/15/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 0/7

0.00

Memo

0.00

Packaging

Ref/ps *(26)*

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/06/29 *mf* *10-6-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 15, 2010 1:06:16 PM

Page 1

Work Order ID: 59873



Parent Item: D2585

Parent Item Name: Mounting Channel

Start Date: 6/15/2010

Required Date: 6/21/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D 04.02.16 Reformat; Add Receiving Step KJ/RF
IPP C 06.07.21 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

100

sf

135.2608

0.0157

0.330526



304SS sheet .080



PR 10-6-20

Location

Loc Qty

Loc Code

MAT20

135.2608

113295

135.2608

113295



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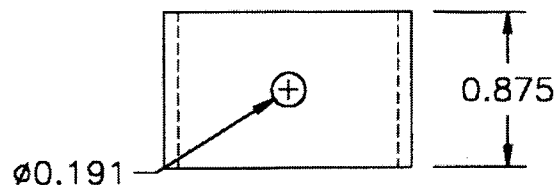
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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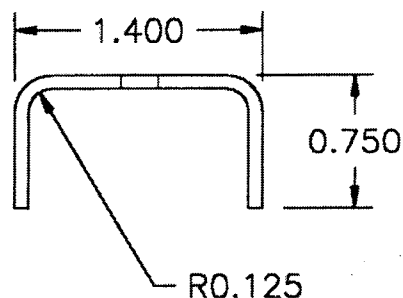
DESIGN BW	DRAWN BY MAY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96:07:11		TITLE MOUNTING CHANNEL	SCALE 1:1
B	97:03:14	ADD FLAT PATTERN	

RELEASED
97/03/14 DS

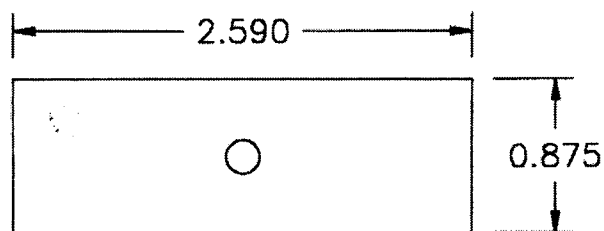


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59823

BS10-6-15



FLAT PATTERN



MATERIAL: 304/316 SS, 14 GAUGE (0.078)

W/O:			WORK ORDER CHANGES					
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